MARKED UP VERSION OF AMENDED SPECIFICATION

Figure 4 illustrates upper and lower weld clamp rings which can be used with a specific embodiment of an ID welding system in accordance with the subject invention.

Figure 5 illustrates how a laser beam can be presented to a weld seam in a specific embodiment of an OD welding system in accordance with the subject invention.

Figure 6 illustrates how a laser beam can be presented to a weld seam in a specific embodiment of an ID welding system in accordance with the subject invention.

Figure 7A and 7B show a comparison in weld penetration between conventional welding methods in Figure 7A and laser welds in 7B.

Figure 8 illustrates the sealed container of bellow diaphragms attached to the bottom of the ID welding station of the present invention.

Figure 9B illustrates a specific weld ring design. **Figure 9A** is a cross section of Figure 9B taken along lines A-A.

Figure 10 illustrates one of the problems with the prior art conventional welding methods.

Figure 11 illustrates the 45° beveled edge of the OD ring.

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CLEAN VERSION OF AMENDED SPECIFICATION

Figure 4 illustrates upper and lower weld clamp rings which can be used with a specific embodiment of an ID welding system in accordance with the subject invention.

Figure 5 illustrates how a laser beam can be presented to a weld seam in a specific embodiment of an OD welding system in accordance with the subject invention.

Figure 6 illustrates how a laser beam can be presented to a weld seam in a specific embodiment of an ID welding system in accordance with the subject invention.

Figure 7A and 7B show a comparison in weld penetration between conventional welding methods in Figure 7A and laser welds in 7B.

Figure 8 illustrates the sealed container of bellow diaphragms attached to the bottom of the ID welding station of the present invention.

Figure 9B illustrates a specific weld ring design. **Figure 9A** is a cross section of Figure 9B taken along lines A-A.

Figure 10 illustrates one of the problems with the prior art conventional welding methods.

Figure 11 illustrates the 45° beveled edge of the OD ring.